

Ship TODAY 04/06

Dart Aerospace Ltd.











Date: Wednesday, 04/06/2008 8:41:01 AM  
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE SPACER				
Job Number	: 39688						
Estimate Number	: 11062						
P.O. Number	:	Part Number	: D2934				
This Issue	: 04/06/2008	S.O. No.	:				
Prsht Rev.	: NC	Drawing Number	: D2934 REV B				
First Issue	: / /	Project Number	: N/A				
Previous Run	: 37368	Drawing Revision	: B				
	Type	: SMALL /MED FAB	Material	:			
Written By	:	Due Date	: 04/06/2008	Qty:	20	Um:	Each
Checked & Approved By	:						
Comment	: Est A 00-06-06 New Issue EC Est Rev:B Now 6061-T6 06-06-23 JLM						

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
		
Comment: Qty.: 0.0334 sf(s)/Unit Total : 0.6678 sf(s) Material: 6061-T6 0.080" Thick Batch <u>104392</u> <u>B</u> <u>8-6-4</u>		
2.0	WATER JET	FLOW WATER JET
		
Comment: FLOW WATER JET 1-Cut as per Dwg D2934 Dwg Rev: <u>B</u> <u>B</u> <u>8-6-4</u> Prog Rev: <u>B</u> 2-Deburr if necessary <u>08/06/04</u> <u>(32)</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B</u> <u>8-6-4</u>		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK <u>08-06-04</u> <u>(32)</u> <u>counted.</u>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <u>B</u> <u>08-06-04</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: SADDLE SPACER

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Part Number: D2934

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/6/4

(32)

SP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5754

8/6/4

(32)

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/04

Job Completion



CMF 08-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

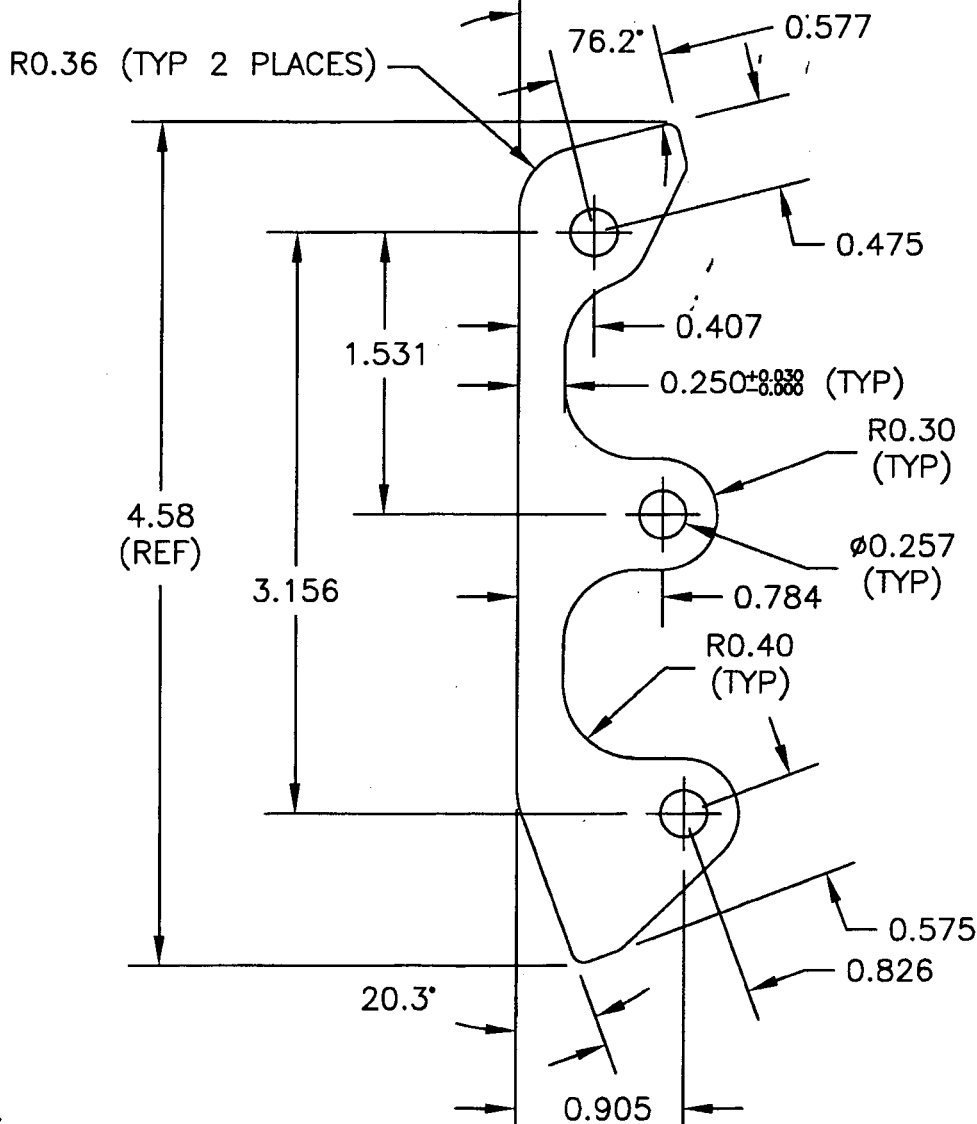
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**DART**

DESIGN #	DRAWN BY C.B.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2934	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**RELEASED**

06.06.20

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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